



Dart Aerospace Ltd.
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POSITIVE RECALL

LIFE TIME - DAS - AUTH

RECALL 55

D206-642-241

Job Sheet 195715

SEP 18 2019

Part No: D206-642-241

Job Qty: 1 pcs

Part Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV F(DEO) IPP Rev: 04.12.02 Revised procedural steps KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verf:EC IPP rev Q 10.02.19 per PAR 09-043 EC verified by: DD IPP Rev R 12.11.22 now swage per ecn12-679 DD verf:JLM IPP Rev:S 14.04.24 ECN14-520 DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Workcenter / Supplier Lead Time	Sign-off
110	Skidtubes - 1	1 pcs	7/5/19	7/5/19	0.00	2.22	Skidtubes - 1		DD
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		SE
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 5	1 pcs	7/5/19	7/5/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS 24	
							QC 5 - 24	9-89	
							QC 5 - 3		JUN 13 2019
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	QC 9	1 pcs	7/5/19	7/5/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24	DAS 24	JUN 13 2019
							QC 9 - 43	9-89	
							QC 9 - 50		
							QC 9 - 9		



Container No: S189817

Part: D206-642-241

Job No: 195715

Serial No/Batch: S189817

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17, TC STC SH98-4 Issue 2, EASA STC

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Plex 5/30/19 9:07 AM Dart, Guerin, Kimberley

140 Handfinish - 1-1 Chemical- B4B	1 pcs	7/5/19	0.00 0.33	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	JUN 13 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	7/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	N/C
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	

				QC 7 - 24		
				QC 7 - 43		
160 Skidtubes - 2 - B4B	1 pcs	7/5/19	0.00 2.50	Skidtubes - 1 - B4B		DP
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
180 Skidtubes - 3 - B4B	1 pcs	7/5/19	0.00 2.50	Skidtubes - 1 - B4B		DP
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
190 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		BE
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
200 Skidtubes - 4 - B4B	1 pcs	7/5/19	0.00 2.50	Skidtubes - 1 - B4B		DP
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		BE
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
220 QC 9	1 pcs	7/5/19	0.00 0.00	QC 9 - 10		
				QC 9 - 18		
				QC 9 - 24		DAS 24 JUN 25 2019
				QC 9 - 43		9-89
				QC 9 - 50		
				QC 9 - 9		
				QC 9 - 10		
230 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		DAS 24 JUN 25 2019
				QC 5 - 24		9-89
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		



				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
240 Handfinish - 2-1 Pressure- B4B	1	7/5/19	0.00 0.33	Handfinish - 2 - 1 - B4B	★ JUN 2 2019
pcs				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
250 Powdercoat - 1 White Gl(A)- B4B	1	7/5/19	0.00 0.28	Powdercoat - 1 - B4B	BL 19-7-3
pcs				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
260 QC 3	1	7/5/19	0.00 0.00	QC 3 - 10	BFB 19-07-03
pcs				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	KL 19-7-6
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
270 Handfinish - 3-1- WingWalk- B4B	1	7/5/19	0.00 1.06	Handfinish - 3 - 1 - B4B	
pcs				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
300 QC 5	1	7/5/19	0.00 0.00	QC 5 - 10	SEP 1 0 2019
pcs				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40
310 Packaging 3-1 - Stock - B4B	1	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
pcs				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
315	DC - 1 - B4B	1	7/5/19	0.00 0.00	DC - 1 - B4B
		pcs			DC - 2 - B4B
320	QC 21 - FG	1	7/5/19	0.00 0.00	QC 21 - FG - 21
		pcs			QC 21 - FG - 70
					QC 21 - FG - 53

Part Op 110 - 1-Debur Fwd edge of tube 2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650 3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. 4-Grind weld flush to cap on top surface only. 5-Cut Aft end as per dwg D2650 from front of tube and Debur 6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650 7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025. 8-Drill pilot holes using Dt 8167. 9-Locate DT8732A from Inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732B & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732A & doubler leaving DT8732B for added support. 10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time. 11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. 12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650 13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder 14-Remove indexing edge using DT9779 as per Dwg D2650. Leave 0.070" wall minimum. 15-C'sink GHW rivet holes as per Dwg D2650 16-Open crossbolt holes to Ø0.375" 17-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6. 18- Ream crossbolt spacer holes to 0.377". 19-

120 - (QC5- Inspect part completeness to step on W/O)

130 - (QC9- Inspect visual per QSI004- Fusion Welds)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - 1- Open and c'sink one crossbolt spacer holes as per Dwg D2650 (DEO Detail B)(without cutting fluid) 2-Debur and blow out all chips from inside the tube

180 - 1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required 2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting

190 - (QC5- Inspect part completeness to step on W/O)

200 - 1-Remove alodine in one area per DEO detail B from around hole and prepare for welding 2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. 3-Grind welds flush as per Dwg D2650. 4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required. 5- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002

- 220 - (QC9- Inspect visual per QSI004- Fusion Welds)
 230 - (QC5- Inspect part completeness to step on W/O)
 240 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.
 250 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: _____ FINISH TIME: _____
 260 - (QC3- Inspect Part Finish)
 270 - (Wing Walk as per dwg QSI005 4.4 Batch 5185147) 1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. 2-Install D2680-041 Nut Plate as per Dwg D2650
 300 - (QC5- Inspect part completeness to step on W/O)
 310 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D206-642-241
 315 - Photocopy bluefile & type labels per PPP D206-642-241 CHG007
 320 - (QC21- Final Inspection - Work Order Release)

Sika Flex 5163437 Exp 19/09

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 pcs (1 ea)	110-Skidtubes - 1	M.H. 080712
D2647	Cap	1 pcs (1 ea)	110-Skidtubes - 1	515744
D3286-1	Doubler	2 pcs (2 ea)	110-Skidtubes - 1	5166098
CR3212-4-04	Cherry Rivet	52 Ea (52 ea)	180-Skidtubes - 3 - B4B	5176117
D2654-3	Web	1 pcs (1 ea)	180-Skidtubes - 3 - B4B	5171694
D2649	Cross Bolt Spacer	1 pcs (1 ea)	200-Skidtubes - 4 - B4B	5167601
D3286-3	Spacer	2 pcs (2 ea)	200-Skidtubes - 4 - B4B	5156881
D4720-1	Spacer	17 pcs (17 ea)	200-Skidtubes - 4 - B4B	5173052
ALS4-1032-130	Rivnut	44 Ea (44 ea)	270-Handfinish - 3-1- WingWalk-B4B	5173039
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	5057257
D2651-1	Plug	18 pcs (18 ea)	270-Handfinish - 3-1- WingWalk-B4B	5160607
D2651-3	O-Ring	18 pcs (18 ea)	270-Handfinish - 3-1- WingWalk-B4B	5167951
D2680-041	Nut Plate	1 pcs (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	5027453
D3537-1	Wearpad	4 pcs (4 ea)	270-Handfinish - 3-1- WingWalk-B4B	F141543
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	5181203
D4956-13	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	5183624
D4956-21	Wearplate Center	1 pcs (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	5174918
D4956-33	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	5206197
MS27039-1-08	Screw	46 Ea (46 ea)	270-Handfinish - 3-1- WingWalk-B4B	5077815
MS27039-4-06	Screw	1 Ea (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	5180295
NAS1149D0332J	Washer	46 Ea (46 ea)	270-Handfinish - 3-1- WingWalk-B4B	5166974-1
NAS1149D0463J	Washer	1 Ea (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	5178378
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	270-Handfinish - 3-1- WingWalk-B4B	5055952
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	270-Handfinish - 3-1- WingWalk-B4B	FM137622
				FM137886-0

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	4	0
	D2647	1	43	0
	D3286-1	2	36	0
180-Skidtubes - 3 - B4B	CR3212-4-04	52	631	0
	D2654-3	1	10	0
200-Skidtubes - 4 - B4B	D2649	1	70	0
	D3286-3	2	24	0
	D4720-1	17	222	0
270-Handfinish - 3-1- WingWalk-B4B	ALS4-1032-130	44	7,594	0
	CCR264SS3-3	2	159	0
	CR3212-4-03	2	84	0
	D2646	1	33	0
	D2651-1	18	95	0
	D2651-3	18	304	0
	D2680-041	1	11	0
	D3537-1	4	68	0
	D3537-3	1	18	0
	D4956-13	1	5	0
	D4956-21	1	0	0
	D4956-33	1	2	0
	MS27039-1-08	46	467	0
	MS27039-4-06	1	95	0
	NAS1149D0332J	46	3,596	0
	NAS1149D0463J	1	3,447	0
Part Specifications				
Specifications could not be found.				

Plex 5/30/19 9:07 AM Dart.Guerin.Kimberley

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-06	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

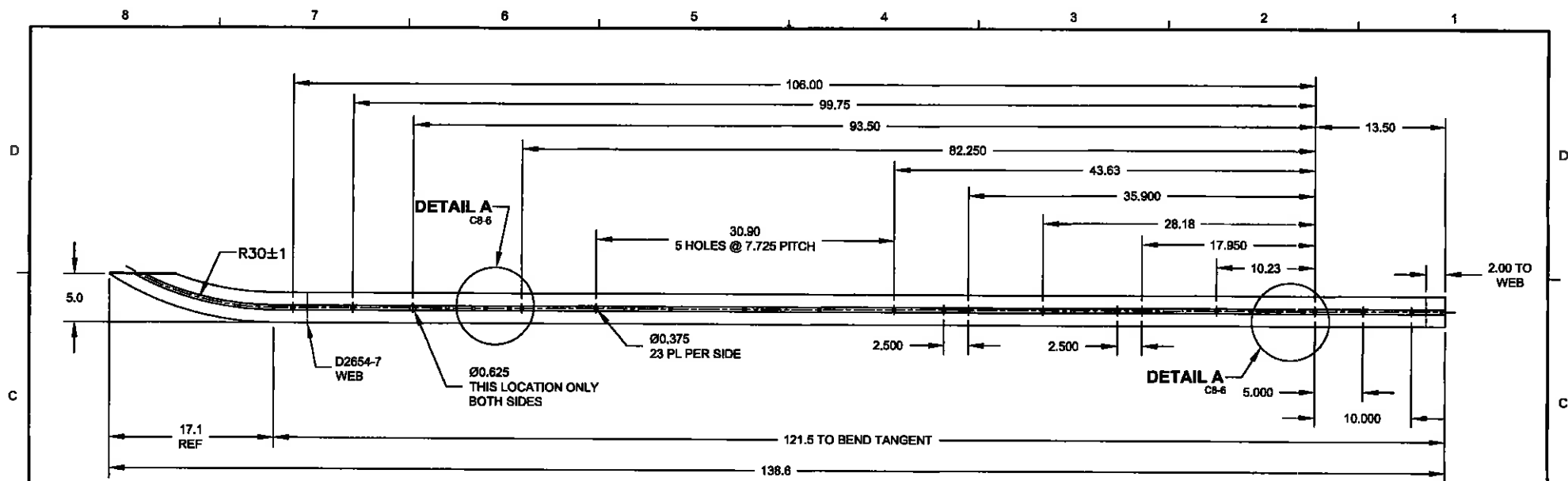
DEO ATTACHED

RELEASED
08-07-23

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 8 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE08138/8153/8163 MOD GROUND HANDLING ON D2650-1/3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



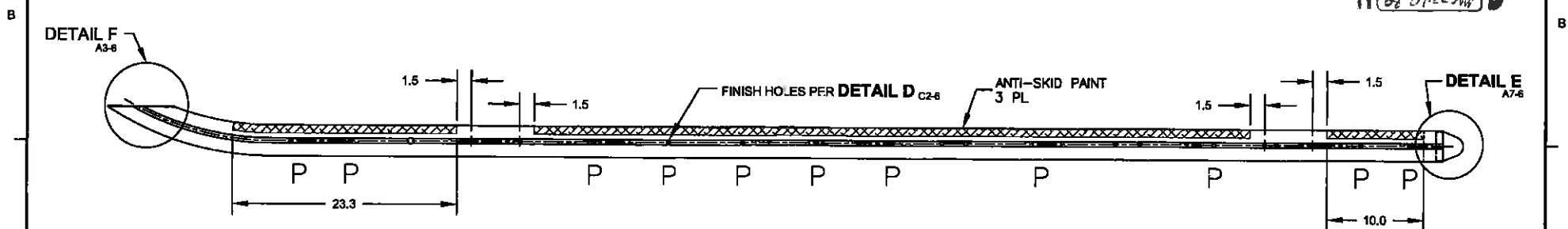
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 4 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	208/407 SKIDTUBE ASSEMBLIES	NTS
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D2650-7 BENDING/DRILL DETAIL

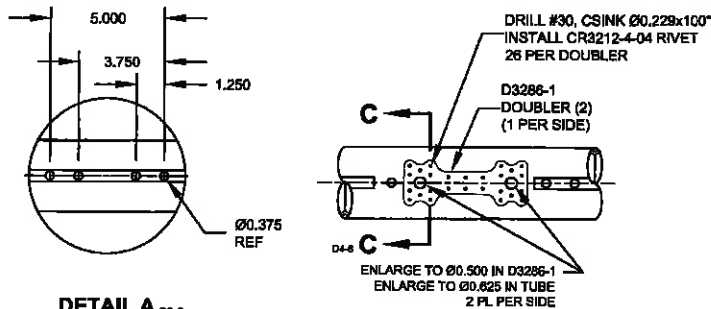
DEO ATTACHED

RELEASED
08 07 22 10/11

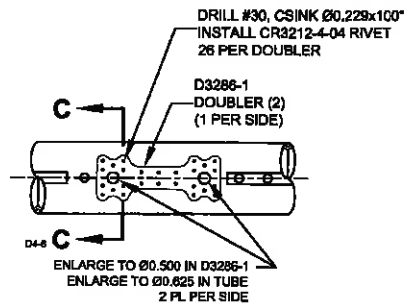


D2650-7 ASSEMBLY/FINISHING DETAIL

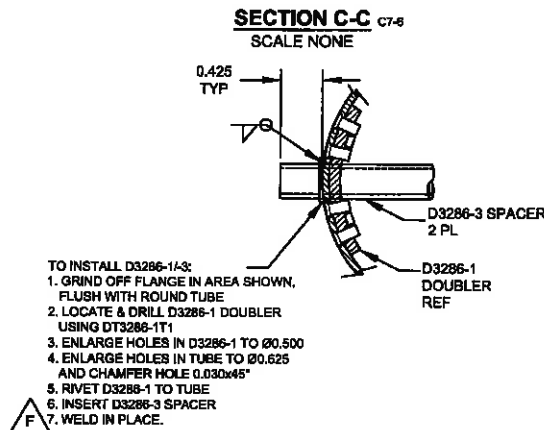
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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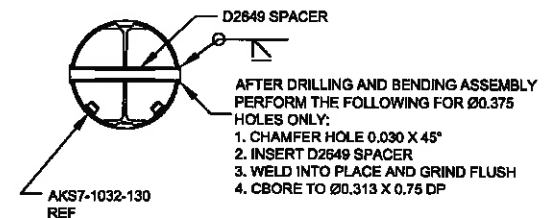
DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5



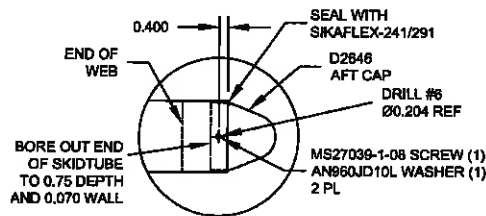
DETAIL B
SCALE 2X
C3-2
C3-3



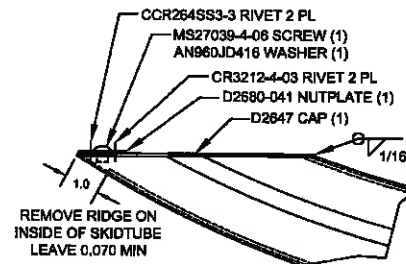
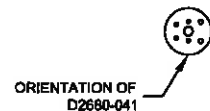
F



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5



DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5



DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
05-09-22-18

DEO ATTACHED

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NT8
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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED <i>A.P.</i>	MFG. APPR. <i>AA</i>	APPROVED <i>JP</i>		DE APPR. <i>JP</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

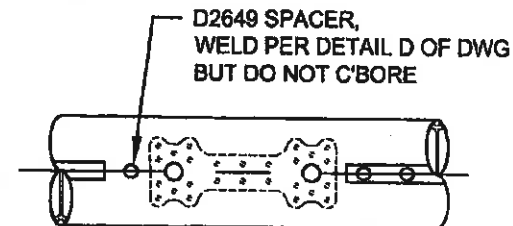
IS:

QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
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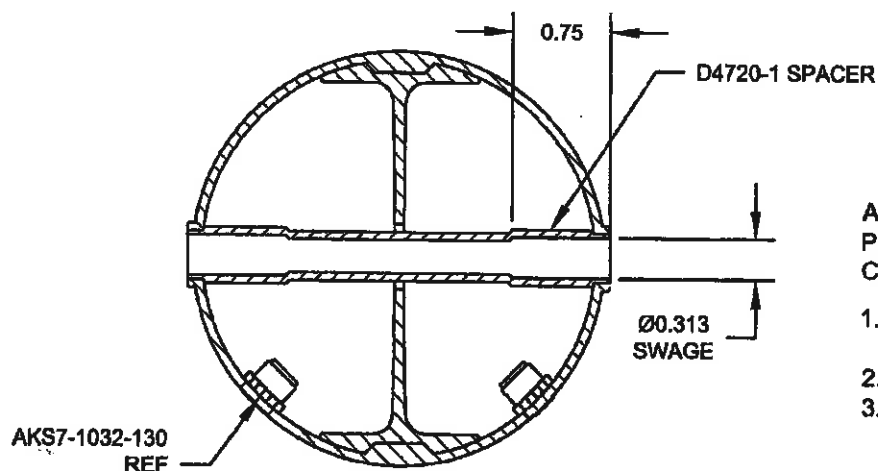
ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.
C'BORED HOLES ARE NOW SWAGED PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
JP



DETAIL G

FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

Change Record

PAGE 1 OF 1

Part Number: D206-642-241

Description: REPLACEMENT SKIDTUBE, LH/RH

[illegible]

